



## PC-ABS Sparkling Filament

1.75 mm · 1 kg spool

Experience superior heat resistance with the OzFDM PC-ABS 1.75mm  $\pm$  0.05 1KG filament. Featuring a heat deflection temperature of 123° Celsius, this PolyCarbonate-ABS Filament is an ideal choice for producing 3D-printed components that require exceptional heat resistance.

✓ PC toughness, ABS printability

✓ Heat deflection 123 °C

✓ Sparkling colour range

## RECOMMENDED PRINT SETTINGS

|                    |                                    |
|--------------------|------------------------------------|
| Nozzle temperature | 250 – 280 °C (265 °C recommended)  |
| Bed temperature    | 90 – 110 °C (100 °C recommended)   |
| Print speed        | 40 – 60 mm/s (50 mm/s recommended) |
| Support material   | HIPS                               |
| Drying             | 80 °C for $\geq$ 12 h              |

## FILAMENT SPECIFICATIONS

|                       |                               |
|-----------------------|-------------------------------|
| Diameter              | 1.75 mm                       |
| Dimensional tolerance | $\pm$ 0.05 mm                 |
| Net weight            | 1 kg                          |
| Density               | 1.14 – 1.15 g/cm <sup>3</sup> |

## SPOOL &amp; PACKAGING

|                      |                   |
|----------------------|-------------------|
| Empty spool weight   | 150 g             |
| Full spool weight    | 1.15 kg           |
| Spool outer diameter | 200 mm            |
| Spool hub diameter   | 52 mm             |
| Spool width          | 65 mm             |
| Shipping weight      | 1.3 kg            |
| Box dimensions       | 210 × 210 × 75 mm |

## AVAILABLE COLOURS (8)



Black



Beige



Red



Green



Blue



Lime



Orange



Purple

## MECHANICAL PROPERTIES

|                             |                               |
|-----------------------------|-------------------------------|
| Tensile Strength ISO 527    | 43.5 – 45.5 MPa               |
| Elongation at Break ISO 527 | 24 – 26 %                     |
| Flexural Modulus ISO 527    | 800 – 950 MPa                 |
| Flexural Strength ISO 178   | 71.5 – 74.5 MPa               |
| Impact Strength ISO 180     | 43.5 – 44.5 kJ/m <sup>2</sup> |

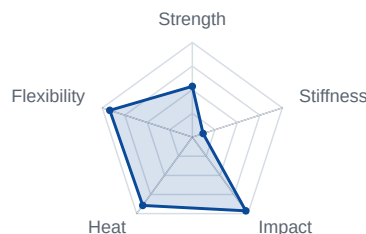
## THERMAL &amp; PHYSICAL PROPERTIES

|                                          |                  |
|------------------------------------------|------------------|
| Heat deflection (0.455 MPa) ISO 75       | 123 °C           |
| Continuous Use Temperature IEC 60216     | 130 °C           |
| Melt flow rate (250 °C/2.16 kg) ISO 1133 | 19 – 22 g/10 min |
| Moisture absorption (23 °C/24 h) ISO 62  | < 0.8 %          |

## STORAGE &amp; HANDLING

Airtight bag or container with desiccant in a cool, dark, dry place. For long-term storage, dry the filament before vacuum-sealing it with desiccant.

## PROPERTY PROFILE



Relative to the OzFDM filament range